

Date: Thursday, 2/9/2006 1:46:03 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY		
Job Number	25761A	Part Number	: D2989041		
Estimate Number	10206	Drawing Number	: D2989 REV B		
P.O. Number	N/A	Project Number	: N/A		
This Issue	2/9/2006	S.O. No.	: N/A		
Prsh Rev.	NC	Drawing Revision	: B		
First Issue	N/A	Material	: N/A		
Previous Run	25759A	Due Date	: 3/20/2006		
Written By	<u>See comment below</u>			Qty:	1 Um: Each
Checked & Approved By	<u>JF 06.02.10</u>				
Comment	: Est Rev:I Removed D2989-043 05-11-03			JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: B258910

AA 06/03/20

2.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2581 Mounting Brackets B25834

AA 06/03/20

3.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2327-3 Bushing B24874

(2)

AA 06/03/20

4.0	D2506	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch
1 D2506 Label Plate B24875

(1)

AA 06/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:46:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25761A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal M100230

(15)

M 06/03/22

6.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing. M100138 → 9313
Batch: M100282 → 243"

M 06/03/22

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

M 06/03/22 (1)

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

8.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-03-22 (1)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

M 06/03/22 (1)

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19640

Wing Walk: 100037

M 06/03/23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 25761A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JGC-03-24

(1)

Comment: Inspect Powder Coat and Wing Walk

11.0 DC

DOCUMENT CONTROL



(1)

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-03-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05.08.19

PARTS LIST:

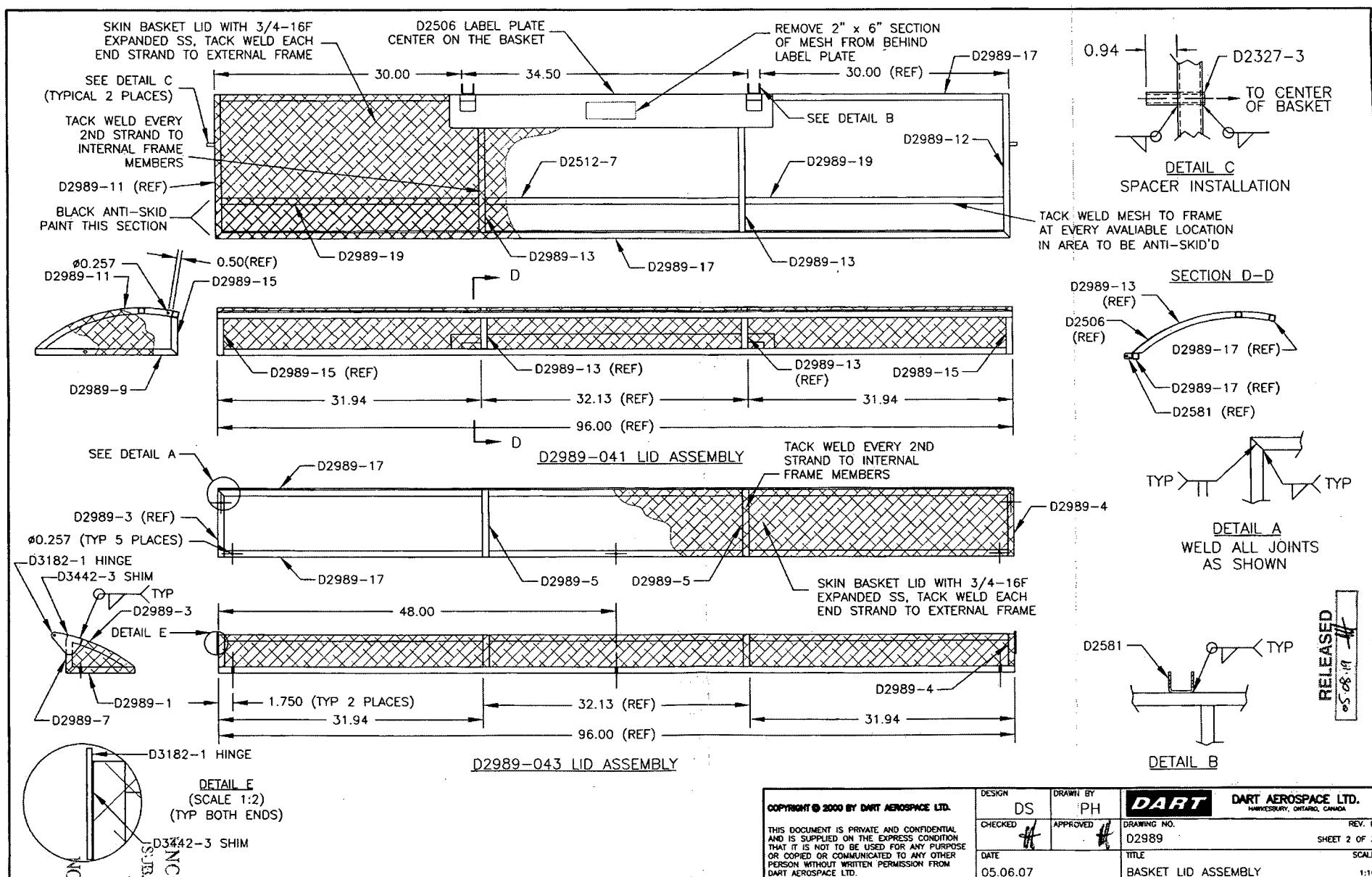
Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
2		D3182-1	HINGE
2		D3442-3	SHIM

NOTES:

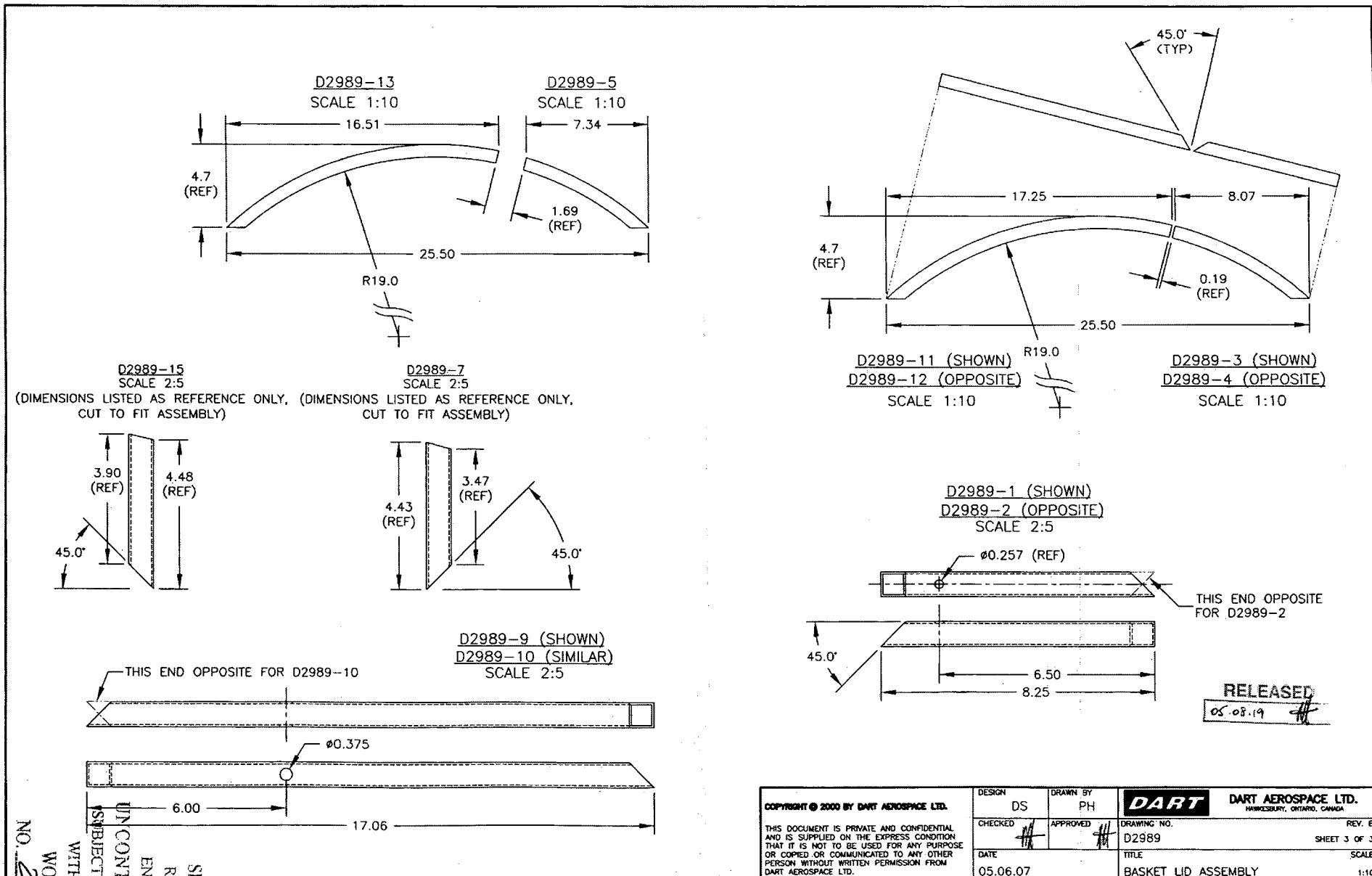
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236 SHOP COPY
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16)
3) WELD PER DART QSI 004 RETURN TO ENGINEERING
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005.4.3. UNCONTROLLED COPY
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005.4.4. SUBJECT TO SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID. WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES WORK ORDER
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO. 25761A

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COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. MANCHESTER, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2989	REV. B SHEET 2 OF 3
		DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE 1:10



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		CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2989	REV. B
		DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	SHEET 3 OF 3

WORK ORDER NO. 25761A
 SUBJECT TO AMENDMENT
 WITH-OUT NOTICE
 UN-CONTROLLED COPY
 ENGINEERING RETURN TO
 SHOP COPY